

SYSTEM #3

MATERIAL: CARBON STEEL

ENVIRONMENT: "TYPE M." MODERATE ATMOSPHERIC CONDITIONS.

SCOPE: TOTAL COATING OF PREVIOUSLY PAINTED, UNPAINTED, OR NEW INSTALLATIONS.* AGGREGATE BLASTING ALLOWED. TEST FOR LEAD AND HEAVY METAL CONTENT.

PROCEDURE/SPECIFICATION:

a. **Surface Preparation**

1. NACE 5-95: WATER BLAST AT 5,000 PSI WITH EMULSIFIER; USE A CLEAR WATER RINSE. USE WITH AEDC PROCEDURE NO. 2 (E 19).
2. SSPC SP 6-84: COMMERCIAL BLAST ALL IRON SURFACES. SIZE AGGREGATE TO PROVIDE A 1.0-1.5-MIL PROFILE PATTERN. FIRST COAT MUST BE APPLIED BEFORE FLASH RUSTING OCCURS. USE WITH AEDC PROCEDURE NO. 6 (E 19).

b. **Painting**

PRIMER:	MACROPOXY H.S. EPOXY PRIMER B58Y400 – YELLOW OXIDE, PART A B58V400 – HARDNER PART B SHERWIN-WILLIAMS OR EQUAL
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COATS:	ONE FULL COAT
DFT:	4.0-8.0 MILS
APPLICATION:	SPRAY, BRUSH OR ROLLER

ALTERNATE #1:

FINISH COAT:	INDUSTRIAL ACRYLIC COATING (DTM) SERIES B66-100 GLOSS SHERWIN-WILLIAMS OR EQUAL
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COATS:	TWO FULL COATS
DFT:	3.0 MILS/COAT
APPLICATION:	SPRAY, BRUSH OR ROLLER

CONTINUE ON REVERSE

ALTERNATE #2:

FINISH COAT:	INDUSTRIAL ACRYLIC COATING (DTM) SERIES B66-100 SEMI-GLOSS SHERWIN-WILLIAMS OR EQUAL
COATS:	TWO FULL COATS
DFT:	1.5-2.0 MILS/COAT. 7.0-8.0 MILS TOTAL.
APPLICATION:	SPRAY

*SPECIAL NOTE: ALL WELDS, WELD SPLATTERS, CUTTING SCARS, SHARP POINTS, AND EDGES SHALL BE GROUND SMOOTH. PROVIDE A SMOOTH, CLEAN, SOUND SURFACE AFTER INSTALLATION IS COMPLETED. COATING APPLICATION OF THESE SURFACES SHALL COMPLY WITH THE ABOVE SYSTEMS.